

Work Order ID 60009

Tuesday, June 22, 2010 3:18:36 PM



Page 1

Item ID: D4042-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Rib Assembly

Start Date: 6/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 6-22-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4042

A

100

Weld per dwg A/R S.S. rod Batch: M10875 0.00



Large Fab

Memo

0.00

①

Large Fab

1- Cut D4042-3 as per dwg D4042

2- Drill and chamfer holes as per dwg D4042

3- Remove identification markings

4- Weld bushing in rib and grind weld flush as per dwg D4042

SAD 10-06-22

① PD 10.06.23

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 060623

①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60009

Tuesday, June 22, 2010 3:18:36 PM



Page 2

Item ID: D4042-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Rib Assembly

Start Date: 6/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00

5/10/06/23



QC

Memo

0.00

Quality Control

AD

130

Identify as per dwg & Stock Location: bucket

0.00



Packaging

Memo

0.00

Packaging

D AD 10.06.23

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/24

Pd 10-6-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 22, 2010 3:18:41 PM

Page 1

Work Order ID: 60009

Parent Item: D4042-043

Parent Item Name: Aft Rib Assembly



Start Date: 6/22/2010

Required Date: 7/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10.01.07 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4021-9		Manufactured	No			100	Each	24.0000	2	2			
Bushing													

Location	Loc Qty	Loc Code
WA	24	
56094	2	
58701	6	
59838	16	

M304TS0.750W.049		Purchased	No			100	f	446.7945	2.04166	2.149116			
304 SQ Tube .75x.75x.049W													

Location	Loc Qty	Loc Code
MAT	146.7944919	
113763	0	
114323	28.3020789	
114677	14.34201	
114835	104.150403	
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	300	
114992	300	

PD 10.06.23

2

SAD 10-06-23

2.149116

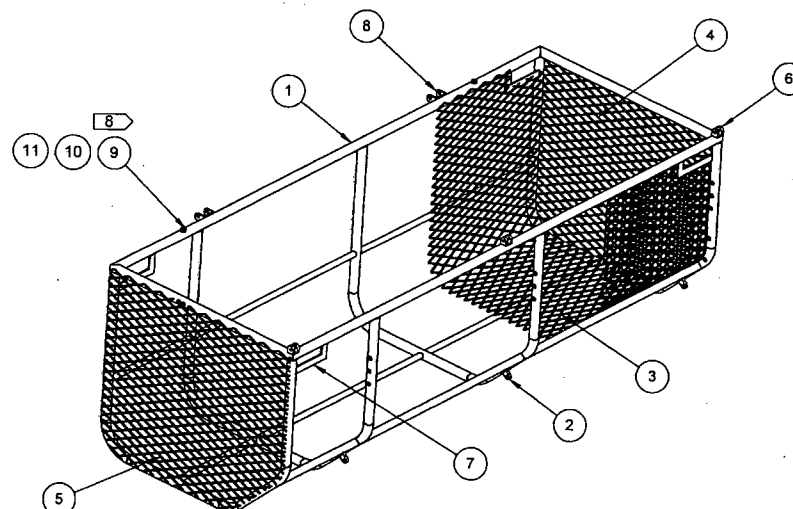
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4042-041 SHORT BASKET ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 28.82 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) TRIM LOCALLY AS REQUIRED TO CLEAR FASTENERS/STRUCTURE
- 10) WELD PER DART QSI 004

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4042-041	SHORT BASKET BASE ASSY, LH
1	1	D4042-101	BASKET BASE FRAME ASSY, LH
2	3	D4045-1	LUG
3	1	D4046-1	MESH BASKET BASE
4	1	D4046-3	MESH FWD END
5	1	D4046-5	MESH AFT END
6	3	D4016-1	HINGE HALF, BASE
7	4	D4021-1	HANDLE PLATE
8	2	D2581	MOUNTING BRACKET
9	2	D2931	BUMPER
10	2	AN960JD8	WASHER
11	2	MS20600AD4W3	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60009
PS 10-6-22

RELEASED
2010-02-16
MP

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D4042	SHEET 1 OF 11
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	SHORT BASKET BASE ASSY	NTS
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

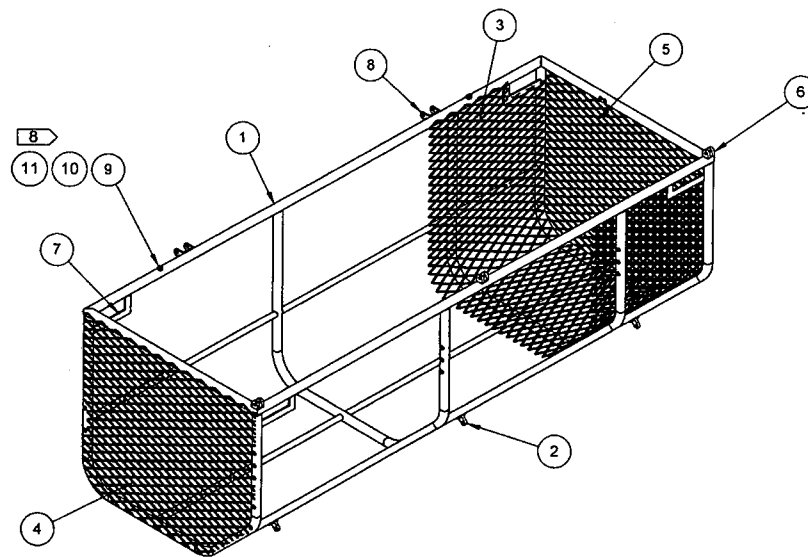
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM	QTY	P/N	DESCRIPTION
	X	D4042-042	SHORT BASKET BASE ASSY, RH
1	1	D4042-102	BASKET BASE FRAME ASSY, RH
2	3	D4045-1	LUG
3	1	D4046-1	MESH BASKET BASE
4	1	D4046-3	MESH FWD END
5	1	D4046-5	MESH AFT END
6	3	D4016-1	HINGE HALF, BASE
7	4	D4021-1	HANDLE PLATE
8	2	D2581	MOUNTING BRACKET
9	2	D2931	BUMPER
10	2	AN960JD8	WASHER
11	2	MS20600AD4W3	RIVET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 28.82 lbs APROX
- 8) INSTALL AFTER FINISH
- 9) TRIM LOCALLY AS REQUIRED TO CLEAR FASTENERS/STRUCTURE
- 10) WELD PER DART QSI 004

D4042-042 SHORT BASKET ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-02-16
JMT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4042	SHEET 2 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SHORT BASKET BASE ASSY	NTS
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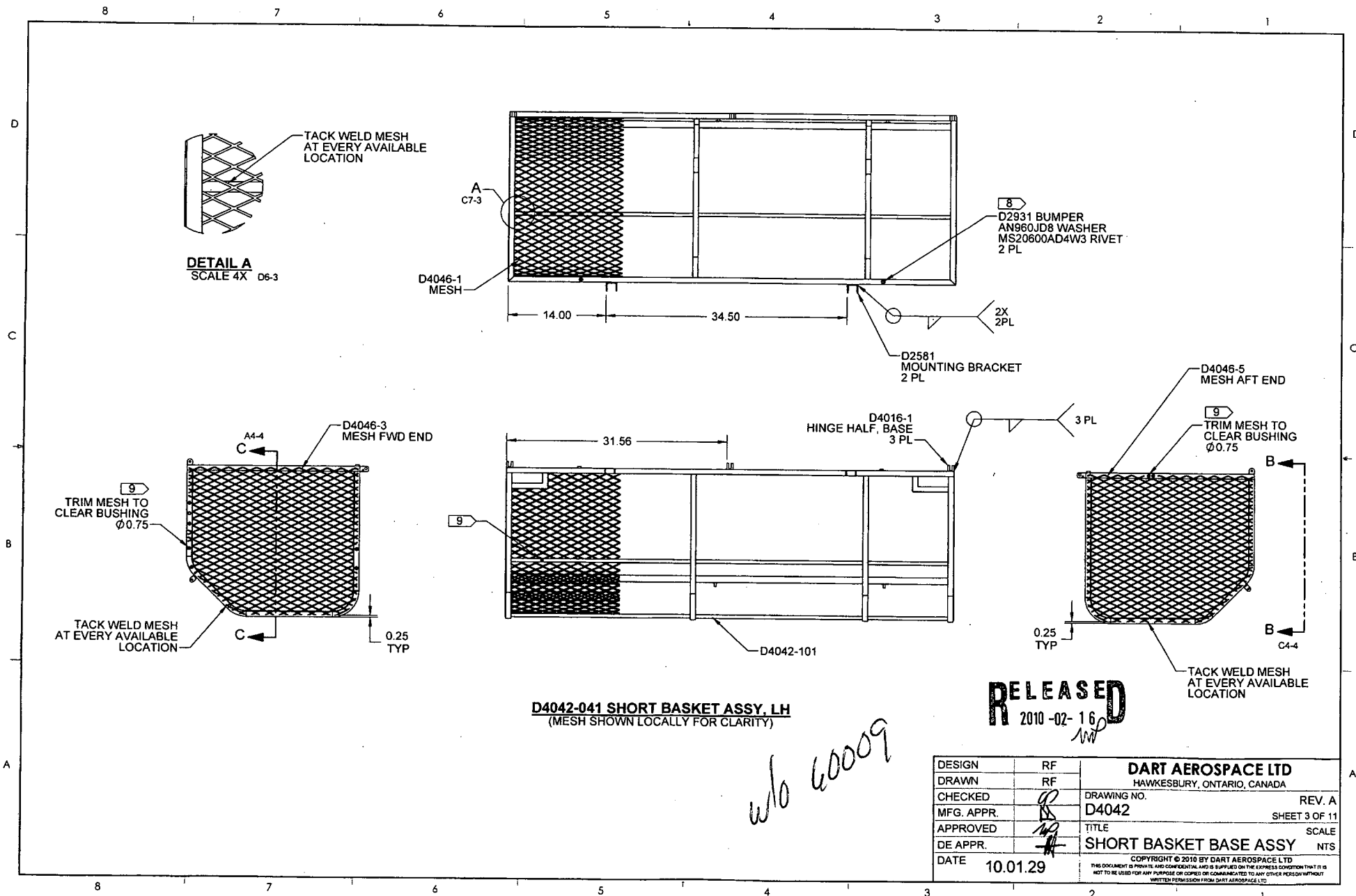
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



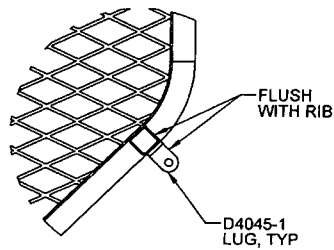
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

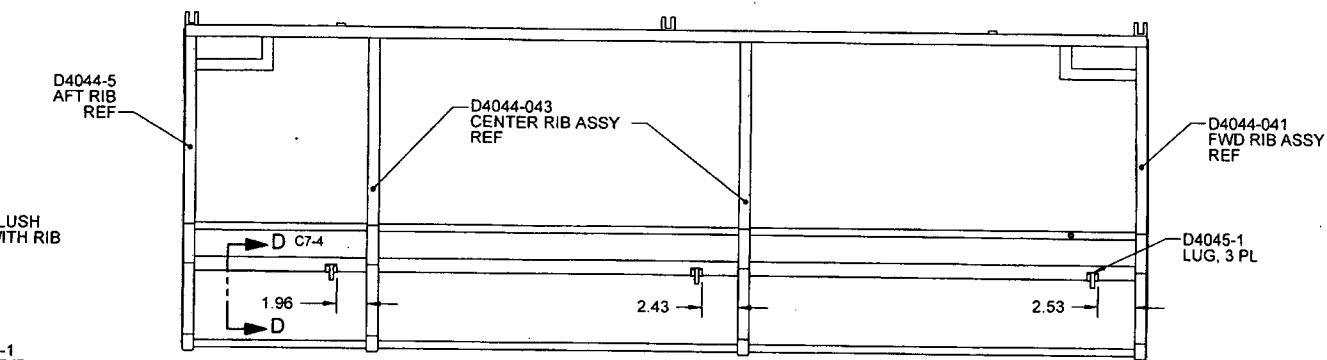
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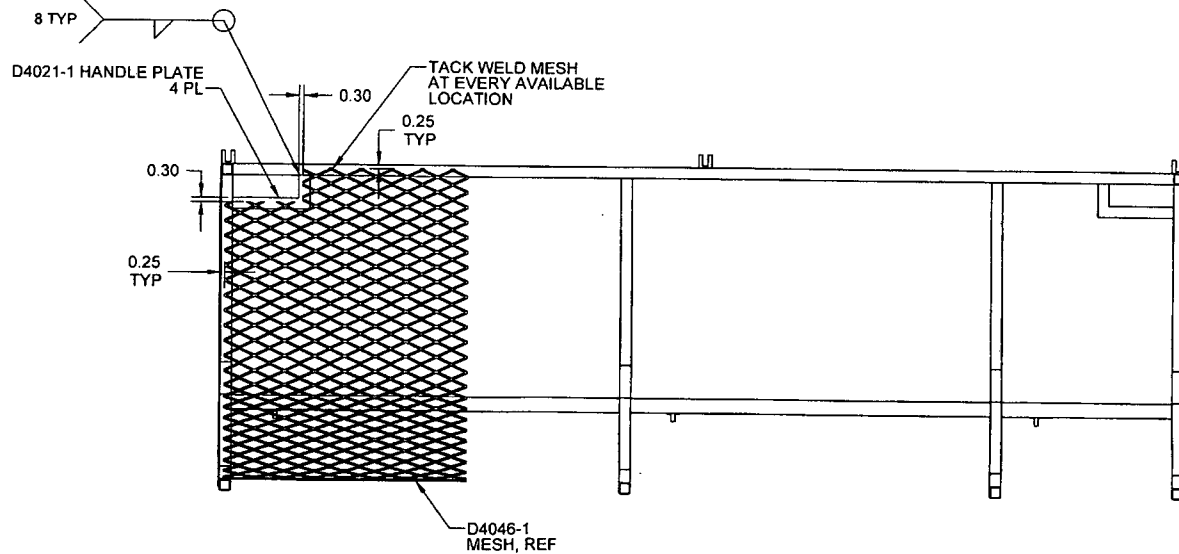
NOTE: Date & initial all entries



SECTION D-D D6-4
SCALE 2X, TYPICAL






VIEW B-B B1-3
(MESH NOT SHOWN FOR CLARITY)
SCALE 3:2X



SECTION C-C C7-3
SIMILAR OPPOSITE VIEW
(MESH SHOWN LOCALLY FOR CLARITY)
SCALE 3:2X

W060009

RELEASED
2010-02-16

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4042	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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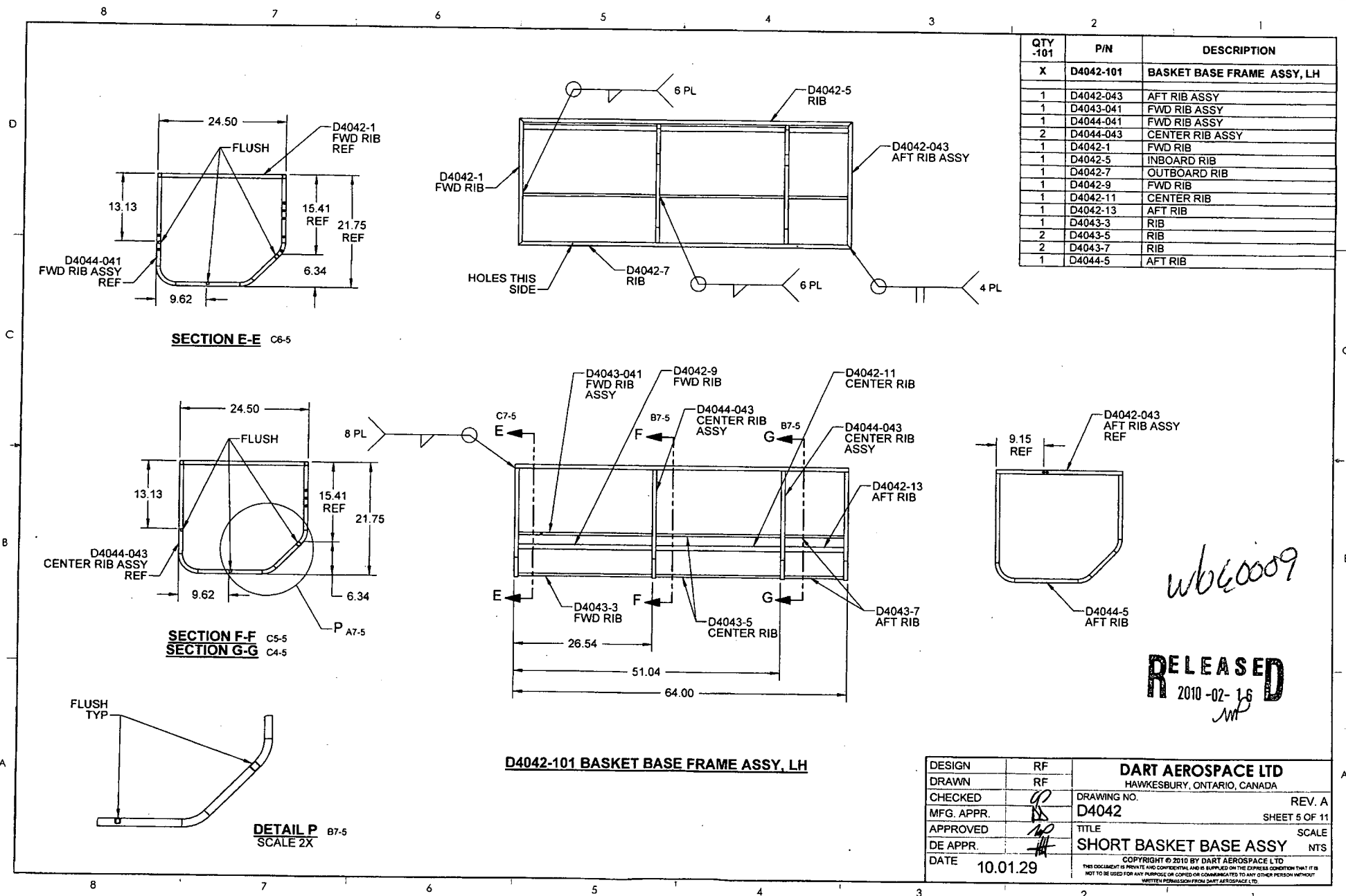
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



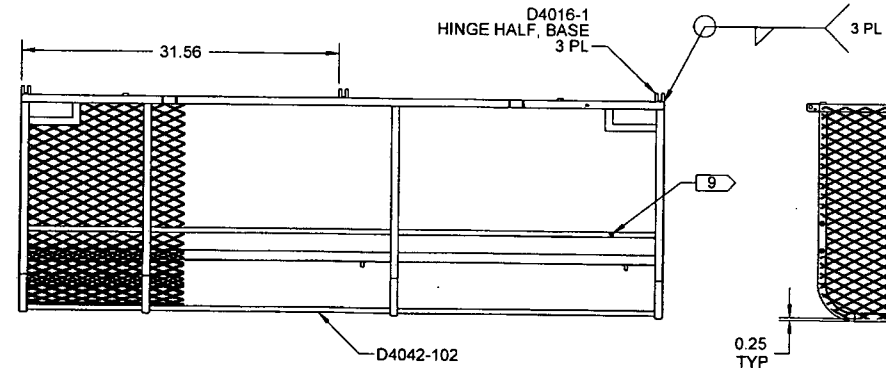
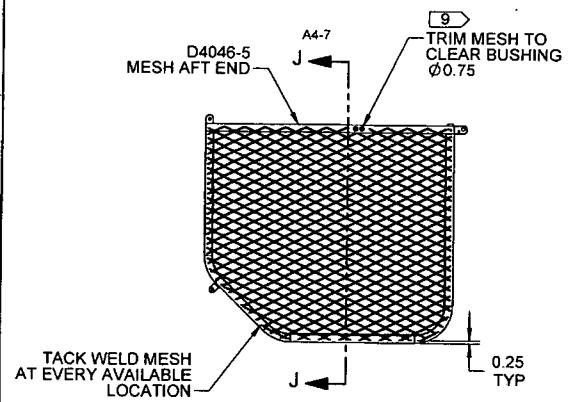
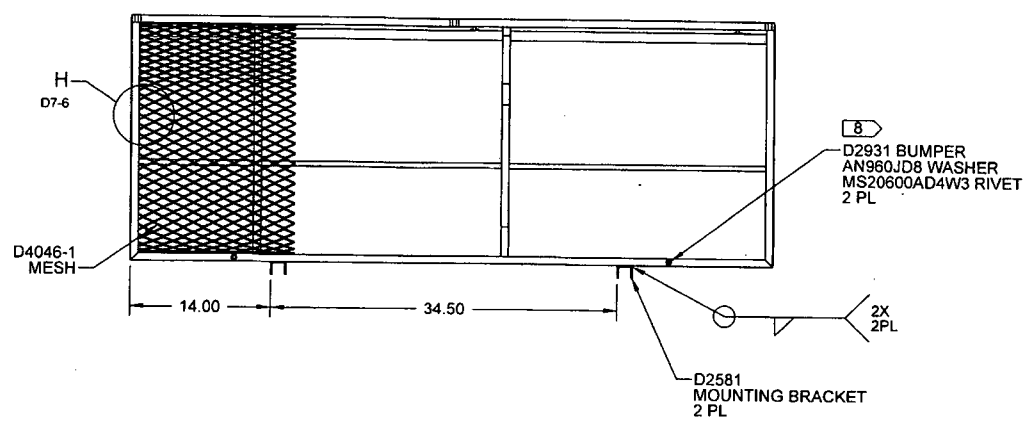
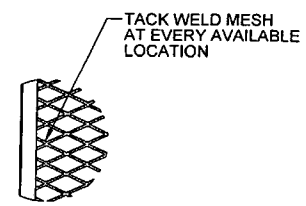
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4042-042 SHORT BASKET ASSY. RH
(MESH SHOWN LOCALLY FOR CLARITY)

w/o 60009

RELEASED
2010-02-16

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JP</i>	D4042	SHEET 6 OF 11
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	SHORT BASKET BASE ASSY	NTS
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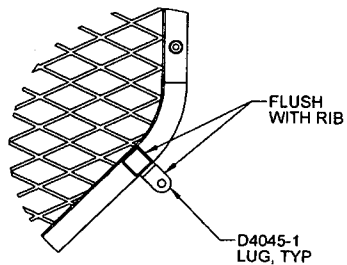
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

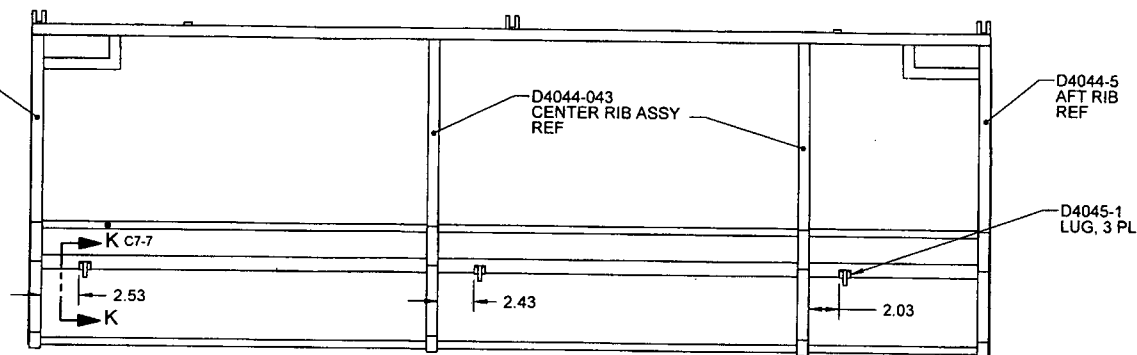
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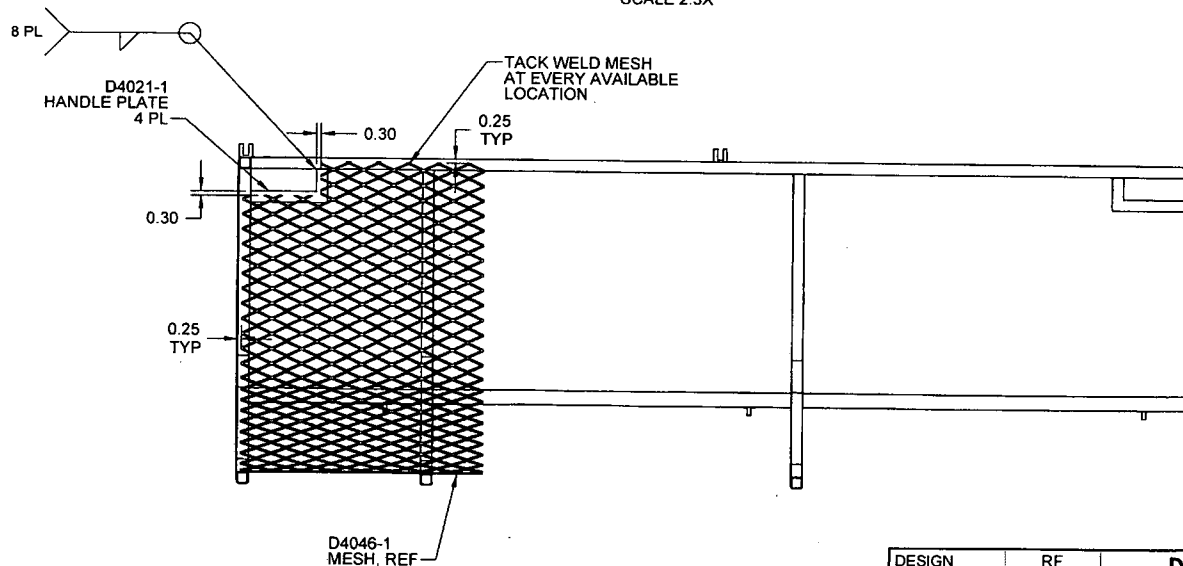
NOTE: Date & initial all entries



SECTION K-K
D6-7
SCALE 2X, TYPICAL



VIEW I-I
C7-6
(MESH NOT SHOWN FOR CLARITY)
SCALE 2:3X



SECTION J-J
C7-6
SIMILAR OPPOSITE VIEW
(MESH SHOWN LOCALLY FOR CLARITY)
SCALE 3:2X

W1060009

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2010-02-16
MP

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>SS</i>	D4042	SHEET 7 OF 11
APPROVED	<i>MP</i>	TITLE	SCALE
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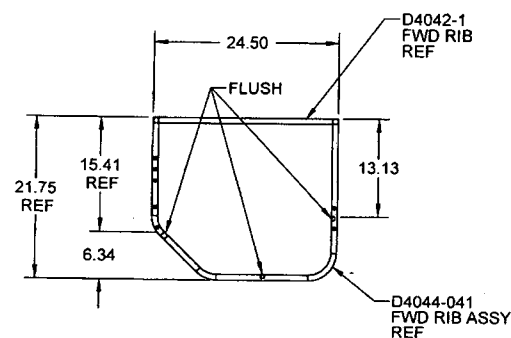
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

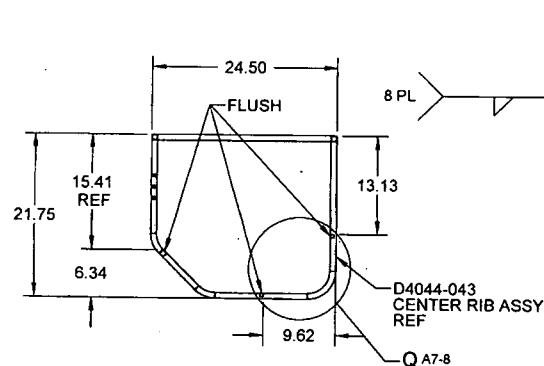
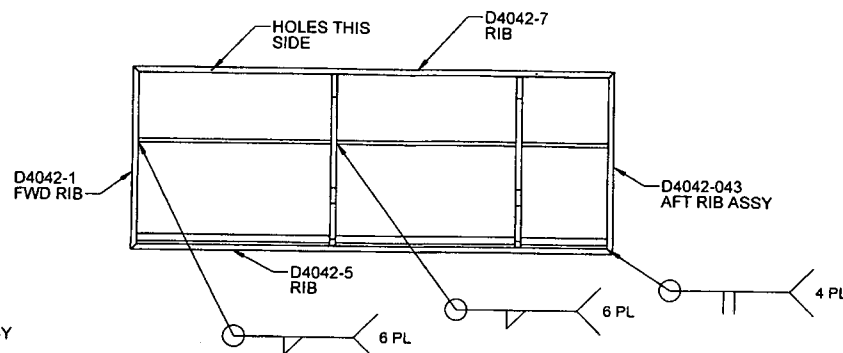
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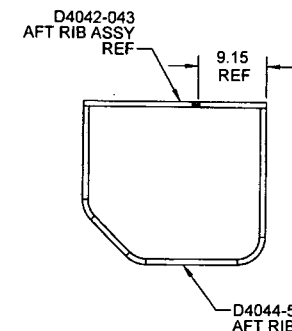
QTY -102	P/N	DESCRIPTION
X	D4042-102	BASKET BASE FRAME ASSY, RH
1	D4042-043	AFT RIB ASSY
1	D4043-041	FWD RIB ASSY
1	D4044-041	FWD RIB ASSY
2	D4044-043	CENTER RIB ASSY
1	D4042-1	FWD RIB
1	D4042-5	INBOARD RIB
1	D4042-7	OUTBOARD RIB
1	D4042-9	FWD RIB
1	D4042-11	CENTER RIB
1	D4042-13	AFT RIB
1	D4043-3	RIB
2	D4043-5	RIB
2	D4043-7	RIB
1	D4044-5	AFT RIB



SECTION L-L C6-4

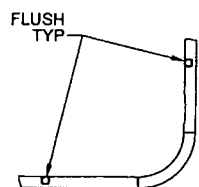


SECTION M-M B5-8
SECTION N-N B4-8



wb 60009

RELEASED
2010-02-16



DETAIL Q B7-8
SCALE 2X

D4042-102 BASKET BASE FRAME ASSY, RH

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>QR</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>QR</i>	D4042	SHEET 8 OF 11
APPROVED	<i>QR</i>	TITLE	SCALE
DE APPR.	<i>QR</i>	SHORT BASKET BASE ASSY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

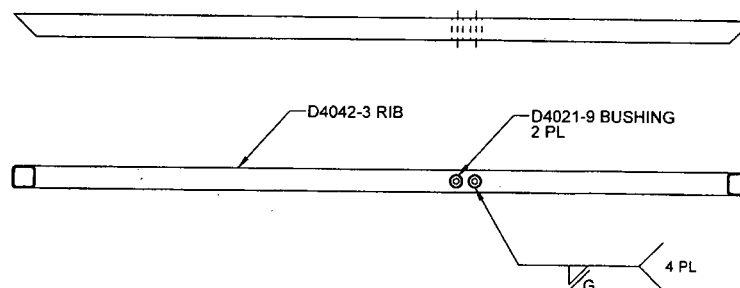
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4042-043	RIB AFT ASSEMBLY
1	1	D4042-3	AFT RIB
2	2	D4021-9	BUSHING



D4042-043 AFT RIB ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.91 lbs
- 8) WELD PER DART QSI 004

Wb 60059
RELEASED
 2010-02-16
Wb

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RF</i>	D4042	SHEET 9 OF 11
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	SHORT BASKET BASE ASSY	NTS
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

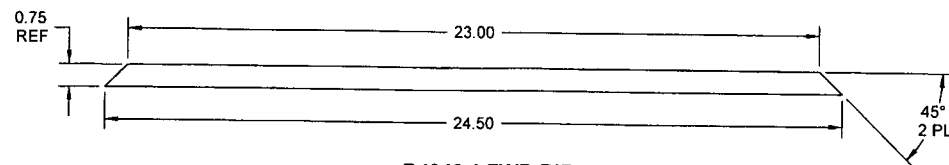
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

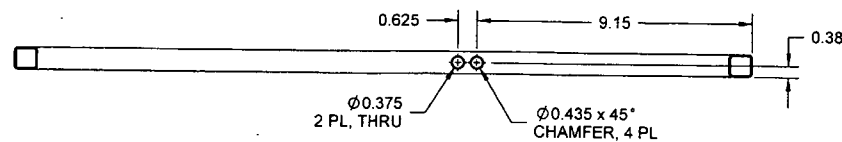
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

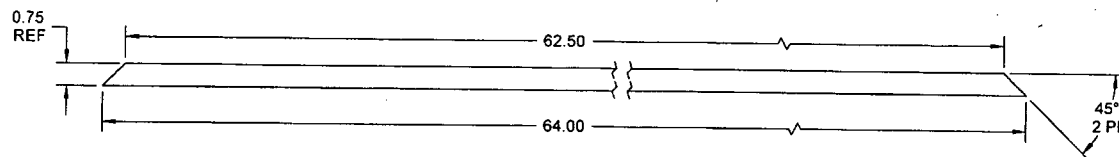
NOTE: Date & initial all entries



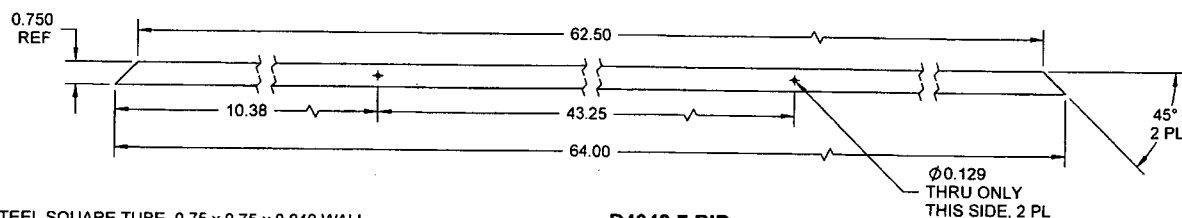
D4042-1 FWD RIB



D4042-3 AFT RIB



D4042-5 RIB



D4042-7 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4042-1: 0.89 lbs
D4042-3: 0.88 lbs
D4042-5: 2.36 lbs
D4042-7: 2.36 lbs

RELEASED
2010-02-16

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4042	SHEET 10 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SHORT BASKET BASE ASSY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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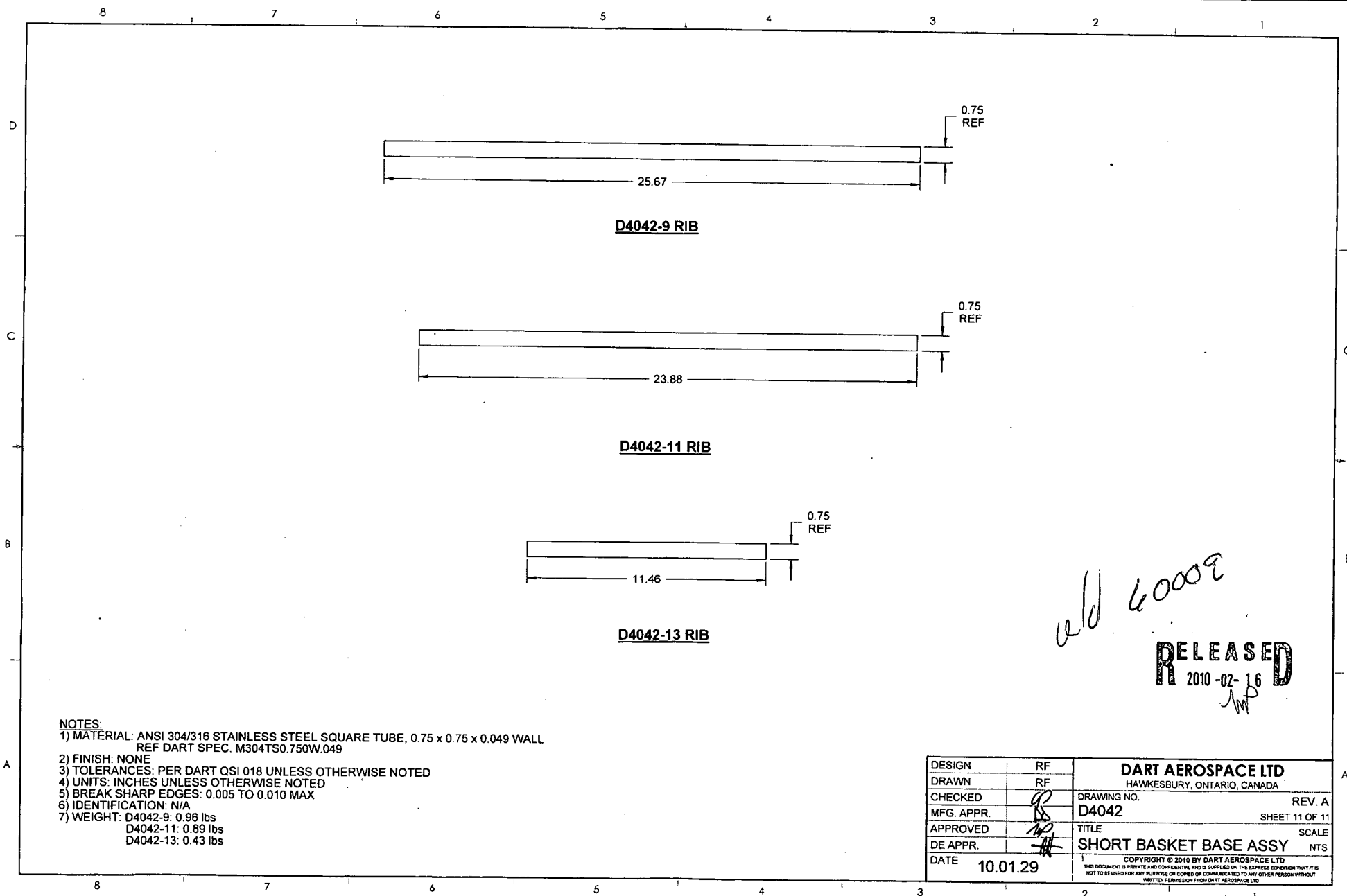
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NOTE: Date & initial all entries



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries